Work Order ID 124504

September-11-14 12:07:46 PM

124504

Page 1

<i>September-11-1</i>	7 12.07.70				wanter							
Item ID: Revision ID:	D3395-1		2	Accept	*N900	040	100)*	Setup	Start	*N	S1*
Item Name:	Bushing									Stop	*N	S2*
Start Date:	9/10/14	Start Qty: 20.0	o *20*		Cust Item 1	ID:						
Required Date Reference:	: 9/10/14	Req'd Qty: 20.0			Customer:							
Approvals:	Process P	lan: MUS	Date: 1409-16	Tooling:	D	ate:			Run	Start	*N	R1*
	QC:		Date:	SPC (Y / N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Re	evision Nbr										
D3395	Re	ev A										
100		H. E. GNG LATTI		0.00								
100 Hardinge		Hardinge CNC LATH Memo	E SMALL	0.00				_20		<u>Ø</u> _		Juf101
Hardinge CNC Lath	he Small	Turn as p	er Folio FA513 and Dwg D339.	5Deburr								
110		QC2- Inspect parts off	machine FAI/FAIB	0.00								1
110								20		Ø		
QC Quality Control		Memo	· ,	0.00								
120		QC8- Inspect parts - se	econd check	0.00								DAS 40
120 QC Quality Control		Memo		0.00				20		<u>Ø</u>		9-89 14/10/20

DQA:			Date:			. WORK ORDER NON		NEOF							DART
QA Closed:			Date:			WORK ORDER NON-	-((JNFOI	RIVIAINCE / UF		Wo	rk Order up	date only		AEROSPACE
						DISPOSITION				AGAINST [DEP	ARTMENT	/PROCESS		
Work Ord	er: .					Powerly .			Skid-tube	Crosstube	П		Water Jet		Engineering
Part I	۱o. ِ					Rework Scrap Use-as-is		ı	Machining noforming	Small Fab Finishing	\exists		d. Eng. Coor. re/Packaging		Quality Other
NCR I	No.					Suspected Unapproved			Large Fab	Composite		Nec/3to	Supplier		
Root			T	<u> </u>	Desc	ription of work order update		nitial	Acti	on	T	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	l	Date	Verification	n	QC Inspector
Design															
Doc/Data	П														
Equip/Tooling														ļ	
Handling/Pre							İ								
Material		,					l								
Operator	Н														
Offset/Setup											١				
Process	П														
Supplier	Н														
Training	Н														
Transport	H													i	
Unapproved	Н														
Onapproved	l		L	<u>. </u>	<u>. </u>		FA	ULT CAT	TEGORY						
Landi	ng (Gear				General									
	_	Bending				Bend]Folio/P	rogram	Γ		Outside Dim	ensions		Pressure/Forced
	-	Centre N	ot Concer	ntric	-	BOM/Route		Grain	· ·			Over/Under	tolerance		Set-up
	${f -}$	Cracks				Broken/Damage/Defect		Hardwa	ire	F		Part Incorred	ci .		Temperature/Cure
		Crimp/Kii	nk/Rinnle	/Wave		Burrs		-	ion Incomplete/Un	gualified		Part Lost/Mi	ssing		Weld
		Cuffs		,	_	Contamination		4	ions Incomplete/U	F	_	Part Moved	Ū		Wrong Stock Pulled
	\vdash	Crushing				Countersink	\vdash	4	ned/off center	ľ		Positioned V	Vrong	<u> </u>	
	-	Heat Trea	at			Cut Too Short	\vdash	Mislabe		}	\neg	Power Loss/			Other
		Inspectio		Tube		Drawing		Misread		L	_	-,	·		I
	_	Marks/Ch			\vdash	Drill Holes	-	Off-set			-		W		
	-	Turning S			<u> </u>	Finish	 	4	Calibration		•		<u>"</u>	_	
	\vdash	Wave/Tw			-	Fit/Function	\vdash	4	Sequence		-		***	_	
	i i						1	1							

Work Order ID 124

124504

Page 2

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Item ID: **Revision ID:** D3395-1

Accept

N900040100

Setup Start

Item Name: Start Date:

Required Date: 9/10/14

Bushing 9/10/14

Start Qty: 20.00 Req'd Oty: 20.00

20 *20*

Cust Item ID:

Customer:

Reference:

Approvals:

OC:

Process Plan:

Date: Date:

Tooling:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/ **Work Center ID** Operation Description Set Up/ **Run Hours** **Tool ID**

Date:

Tool #

Plan Code

Accept Qty

Reject Qty

Reject

Insp. Number Stamp

130

Identify as per dwg & Stock Location: 57036

DAS 28

OCT 2 0 2014

120 Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

Quality Control

QC

Memo

0.00

DQA:			. Date:											"DART
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UF		Vork Order up	ndate only	\neg	AEROSPACE
QA Closed.			Date.									<u> </u>		· · · · · · · · · · · · · · · · · · ·
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS		
***************************************	-					Rework			Skid-tube	Crosstube	7	Water Jet	\neg	Engineering
Part I	No.					Scrap		į	Machining	Small Fab	Pro	d. Eng. Coor.		Quality
	-					Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging		Other
NCR I	۷o.					Suspected Unapproved			Large Fab	Composite		Supplier		
											1	T		
Root					Desc	ription of work order update	į.	Initial	Acti		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	-	QC Inspector
Design	Щ													
Doc/Data	-											•	-	
Equip/Tooling	Щ													
Handling/Pre	$\vdash \vdash$													
Material	Н												-	
Operator	Н													
Offset/Setup														
Process	Н													
Supplier	\vdash													
Training Transport	Н													
Unapproved	Н				.									
опарріотса	1		l	I			FAI	ULT CAT	regory			L		
Landi	ng G	iear				General			· · · · · · · · · · · · · · · · · · ·		****	. #		
	$\overline{}$	Bending				Bend		Folio/F	rogram		Outside Dim	ensions	٦	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain	_		Over/Under	tolerance		Set-up
	П	Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorre	cí [Temperature/Cure
		Crimp/Kir	nk/Ripple,	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	issing		Weld
		Cuffs				Contamination		Instruct	ions Incomplete/U	nclear	Part Moved			Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong		
		Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge		Other
		Inspectio	n Strip in	Tube		Drawing		Misread	d					
		Marks/Ch	natter			Drill Holes		Off-set					_	
		Turning S	equence			Finish		Out of 0	Calibration					
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence					

Picklist Print

September-11-14 12:07:46 PM

Work Order ID: 124504

124504

Parent Item:

D3395-1

D3395-1

Parent Item Name: Bushing

Start Date: 9/10/14

Required Date: 9/10/14

Page 1

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP A05.02.23New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR0.500		Purchased	No			100	f	104.3421	0.0625	1.31579			
MDFI RII Delrin Round Bar .50" colo)							**				10/19
				Location		Loc (<u>Oty</u>	Loc Code					
				MAT039		104.342	2104						
				12	23698	2.473	3684						

101.86842

DQA:			Date:						_					TRAC.
						WORK ORDER NON	-CO	ONFO	RMANCE / UPDATE					AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
Work Orde	or.					DISPOSITION			AGAINST	T DE	PARTMENT	/PROCESS		
Work Orac	-,					Rework	7		Skid-tube Crosstube			Water Jet		Engineering
Part N	۱o.					Scrap	1		Machining Small Fab	1-	Pro	d. Eng. Coor.		Quality
	•					Use-as-is	1	Therr	noforming Finishing	3	Rec/Stor	re/Packaging[Other
NCR N	۱o.					Suspected Unapproved]		Large Fab Composite	-		Supplier		
			1 1						A . 1		C: 0			
Root		5 .	<u>.</u>	<u> </u>	Desc	ription of work order update		initial	Action		Sign &	Verification		QC Inspector
Cause		Date	Step	Qty		or non-conformance	Cn	ief Eng	Description		Date	verification		QC IIISPECTOI
Design	-													
Doc/Data														
Equip/Tooling							Ì							
Handling/Pre														
Material Operator														
Offset/Setup	\dashv										<u> </u>			
Process	\exists										į			
Supplier	\neg													
Training														
Transport														
Unapproved														
							FA	ULT CA	TEGORY		· · · · · · · · · · · · · · · · · · ·	****		
Landi	ng G	Gear			_	General		•			7	-		
		Bending				Bend		4	Program	<u> </u>	Outside Dim		_	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route	<u> </u>	Grain			Over/Under	F		Set-up
		Cracks				Broken/Damage/Defect	<u> </u>	Hardwa		L	Part Incorred			Temperature/Cure
	-	Crimp/Kir	nk/Ripple	/Wave	_	Burrs	<u> </u>	i '	ion Incomplete/Unqualified		Part Lost/Mi	ssing		Weld
		Cuffs				Contamination	<u> </u>	4	tions Incomplete/Unclear	<u> </u>	Part Moved	L		Wrong Stock Pulled
	_	Crushing			\vdash	Countersink		1 7	gned/off center	-	Positioned V			Oth
	-	Heat Trea				Cut Too Short	<u> </u>	Mislabe			Power Loss/	Surge [Other
	-	Inspectio		Tube		Drawing	-	Misrea						
		Marks/Ch			-	Drill Holes	\vdash	Off-set						
	\vdash	Turning S			<u> </u>	Finish	-	-	Calibration					
1		Wave/Tw	rist in Tub	e		Fit/Function		Jout of :	Sequence					

DART AEROSPACE LTD	Work Order:	154204
Description: Bushing	Part Number:	D3395-1
Inspection Dwg: D3395 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.600	+/-0.010	0,602	1/		MJP-04	VIVN
0.060	+/-0.010	0012	/		111	141
R0.010	+/-0.010	R 0010	1/			
0.030 x 20°	0.5°	0 030 X20°				
Ø0.500	+/-0.010	0 496				•
Ø0.191	+0.005/-0.001	0.191				
Ø0.305	+/-0.010	0,062 R 0,010 O,030 X20° O,496 O,191 O,305	/		4	V
Measured by:	Ass P	Audited by		AS IO	Duototus A	

 Measured by:
 Audited by:
 40 9-89
 Prototype Approval:
 N/A

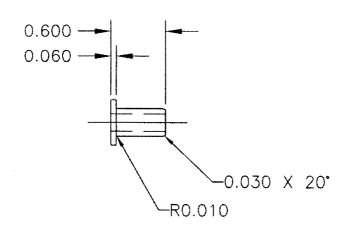
 Date:
 14/10/19
 Date:
 14/10/20
 Date:
 N/A

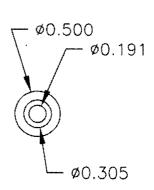
$1 \land 1 \lor 0 \lor 0 \lor 0 \lor 1 \lor 0 \lor 0 \lor 0 \lor 0 \lor 0 \lor$	Approyed	Revised by	Date Change	Rev
Note in the state	911	KJ/JLM CKY	05.0714 New Issue	Α



DESIG	CP	DRAWN BY CP	DA	RT AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHEC	KED ME	APPROVEO	DRAWING NO.		REV. A
	-#-	#	D3395	SHEET	1 OF 1
DATE			TITLE		SCALE
05.0	3.10		BUSHING		1:1
Α		05.03.10	NEW ISSU	JE .	







ENGINEERING

D3395-1 BUSHING

- 1) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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